

Work Order ID 162868***162868***

Page 1

Friday, June 16, 2017 8:12:09 AM

Item ID: D2366

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Lock Handle

Start Date: 6/21/2017 Start Qty: 6.00

6

Cust Item ID:

Required Date: 6/29/2017 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: DAS 21 Date: JUN 16 2017

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2366	Rev C

100

0.00

100

Waterjet

FLOW WATER JET

Memo

0.16

FLOW CNC Waterjet

1-Cut as per Dwg 2366 Dwg Rev: C Prog Rev: C 2-
Deburr if necessarySC 17/06/21

110

0.00

110

QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.06

Quality Control

SC 17/06/21
DAS 44 9-89 17-06-21

120

0.00

120

QC

QC8- Inspect parts - second check

Memo

0.12

Quality Control

Le DAS 38 9-89
JUN 22 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

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17/12/20

U 17.07.11

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Picklist Print

Friday, June 16, 2017 8:12:07 AM

Page 1

Work Order ID: 162868

162868

Parent Item: D2366

D2366

Parent Item Name: Lock Handle

Start Date: 6/21/2017

Required Date: 6/29/2017

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP B00.05.04ReformatEC
IPP Rev:C Now on Waterjet 07-04-20 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased		No		100	sf	118.8200	0.0174	0.109895			

M304S20GA

304/316 .040 Sheet

**

SC 17/06/21

Location

Loc Qty

Loc Code

MAT020

118.82

m136327

3.15

m136568

3.78

m137263

2.5

m137362

10.29

m137513

35.1

m137762

64

9.11

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

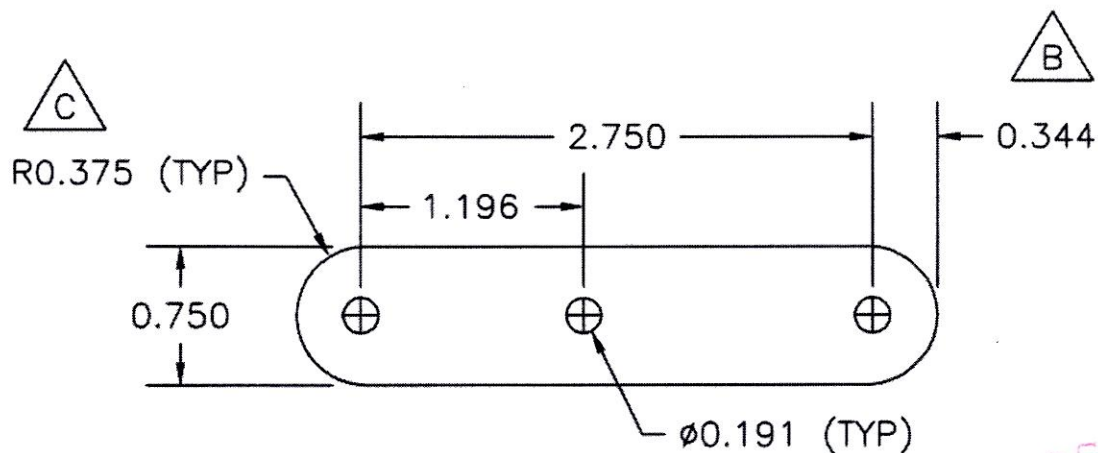
Work Order update only ☐

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2366	REV. C SHEET 1 OF 1
DATE 00.04.24		TITLE LOCK HANDLE	SCALE 1:1
A	95.02.20	NEW ISSUE	
B	96.06.10	R0.50 WAS R0.354; 0.344 WAS 0.300	
C	00.04.24	R0.375 WAS R0.50	

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00.05.02 *[Signature]*



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